

# Work Order ID 71889

Wednesday, July 13, 2011 11:10:03 AM



Page 1

Item ID:	D2056	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bell Crank					
Start Date:	7/14/2011	Start Qty:	20			
Required Date:	7/28/2011	Req'd Qty:	12.00			
Reference:						

Approvals:	Process Plan:	MF	Date:	1-07-13	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2056	Rev B2								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jcaspa Bandsaw	Cut blanks 2.80" long								

- FR 11/07/28  
22 11-07-25

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2056								
	Tumble								
	Deburr								

Issue PO 14572  
to Don's Precision  
machine per drawing D2056 Rev. B2

120		0.00							
	QCZ-Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

Receive & inspect for  
transport damage  
ensure C.I.C. attached

11-08-04

8/4/13 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 71889

Wednesday, July 13, 2011 11:10:03 AM



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Item ID: D2056

Accept



Setup Start



Revision ID:

Item Name: Bell Crank

Stop



Start Date: 7/14/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*Sulley*

*Went*  
*(+20)*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*20 11-9-15*

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

*1:40*  
*320°F*  
*2:10*

*20XØ M-11/04/15*

*M115128*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71889**

Wednesday, July 13, 2011 11:10:03 AM

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Item ID: D2056

Accept

Revision ID:

Item Name: Bell Crank

Start Date: 7/14/2011 Start Qty: 12.00

Required Date: 7/28/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 BR 11-9-15

170

Identify as per dwg &amp; Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

11/9/15 (20)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/15 MF 11-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 13, 2011 11:10:01 AM

Page 1

Work Order ID: 71889



Parent Item: D2056



Parent Item Name: Bell Crank

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP E02.04.04 Added Rev.B2 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	11.8761	0.2375	2.79996			



6061-T6 Bar 1.25 x 1.25



2-11-07-25

## Location

MAT003

116135

117798

## Loc Qty

11.8761

1.68

10.1961

## Loc Code

1.68  
3.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

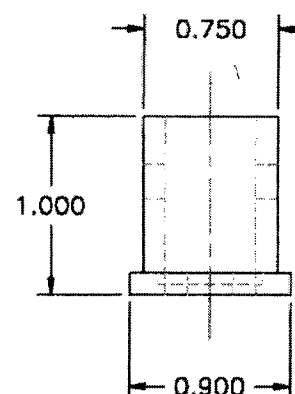
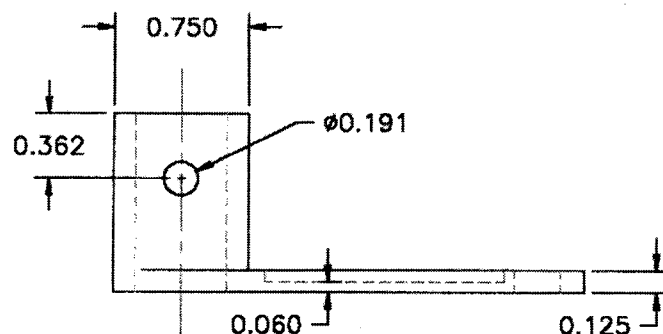
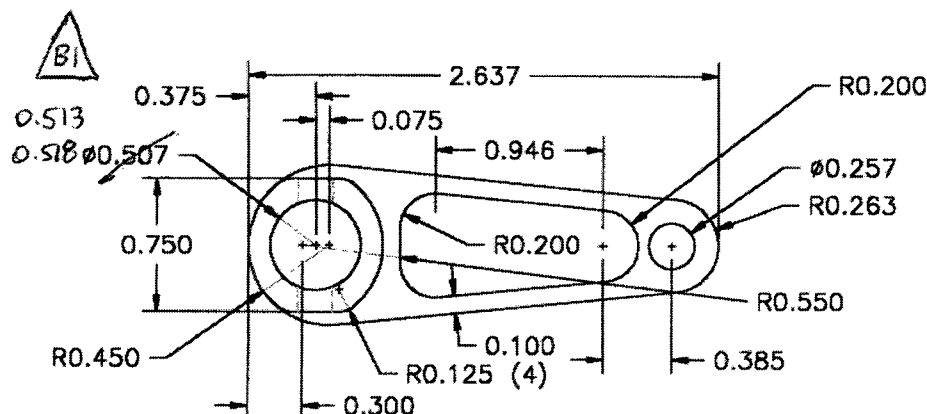


**DART**



RELEASED  
990428 AE

DESIGN	B WILLIAMS	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	<i>AE</i>	APPROVED	<i>AE</i>	REV. B
DATE	92-03-13	TITLE	BELL CRANK	SHEET 1 OF 1
		DRAWING NO.	D2056	
		RE-DESIGN		
		MODIFY HOLE SIZE, ADD FIL OF TUN		
		ADD NOTE ON TOLERANCES		



#71889

**B1** ACID ETCH & ALODINE PER  
DART QSE 005 4.1  
POWDER COAT BLACK STAMEN  
(4.3.5-7) PER DART  
QSE 005 4.3

**B2**

MATERIAL: 6061-T6 (QQ-A-225/8)  
FINISH: ANODIZE (BLACK) OR

TOLERANCES ARE PER DART QSE 018 UNLESS OTHERWISE NOTED.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DAN'S PRECISION TOOLS INC.**

2560 Devine Road, Vars, ON K0A-3H0  
Tel: (613) 835-3097 Fax: (613) 835-3760  
support@dans-precision-tools.com

**PACKING SLIP**

Ship To: DART AEROSPACE LTD.  
1270 Aberdeen Street  
Hawkesbury ON K6A-1K7

Number: 10731

Date: September 12, 2011

Customer's Order: PO14572

Item#	Line#	Qty	Part #	Description	Status
1	3	20	D2056revB2	Bell Crank	Complete

Number of Packages: ☐ Boxes \_\_\_\_\_  
☐ Bags \_\_\_\_\_  
☐ Bundles \_\_\_\_\_

Received by: \_\_\_\_\_ Date: \_\_\_\_\_

**DAN'S PRECISION TOOLS INC.**

2560 Devine Road, Vars, ON K0A3H0  
Tel: (613) 835-3097 Fax: (613) 835-3760  
support@dans-precision-tools.com

**RE: CERTIFICATE OF COMPLIANCE**

**To:** DART AEROSPACE LTD.  
1270 Aberdeen Street  
Hawkesbury ON K6A-1K7  
Tel: (613) 632-5200  
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

**Date** : 12-Sep-11

**Purchase Order** : PO14572

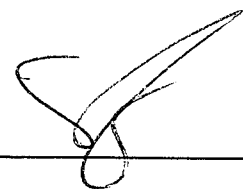
**Packing Slip** : 10731

**Part Number** : D2056revB2

**Quantity** : 20

✓ u/c 114

**Per:** \_\_\_\_\_



**For Dan's Precision Tools Inc.**

**DAN'S PRECISION TOOLS INC.**

Customer: DART AEROSPACE LTD.

P.O.: PO14572

W/O: \_\_\_\_\_

Part #: D2056 rev B2

Bell Crank

Qty: 20

1 of 1


# Work Order ID 76151

**\*76151\***

Page 1

November-08-11 9:56:43 AM

Item ID: D2056 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bell Crank  
 Start Date: 11/08/11 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 11/08/11 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference: to correct costing

Approvals: Process Plan:  Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2056	Rev B2

180 QC21- Final Inspection - Work Order Release 0.00

**\*180\***

QC Memo 0.00  
 Quality Control to pull purchased part to correct costing

*66111-58*

# Picklist Print

November-08-11 9:56:43 AM

Page 1

Work Order ID: 76151

Parent Item: D2056

Parent Item Name: Bell Crank

Start Date: 11/08/11

Required Date: 11/08/11

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP E02.04.04Added Rev.B2 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2056 Bell Crank		Manufactured	No				Each	24.0000		20			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		24							
				71102		4							
				71889		20							
D2056P Bell Crank		Purchased	No				Each	0.0000		20			

Reference	Accounting Labor Amount	Accounting Material Amount
	0.4087	0
Old value 0	0.4087	0
New value 33.1681	0.4087	0
Item Revision Consolidation Automation; Acct#: 60100-50; Emp ID: INS007	0.4087	0
Work Order ID: 54568, Reason: , Employee ID: DCUSER	0.4087	0
	0.4087	0
	0.4087	0
Old value 33.1681	0.4087	0
New value 45.7855	0.4087	0
Work Order ID: 55598, Employee ID: FAUT01	0.4087	0
Work Order ID: 55600, Reason: , Employee ID: FAUT01	0.4087	0
	0.4087	0
2/02/10 9:02	0.4087	0
Work Order ID: 55702, Reason: , Employee ID: DCUSER	0.4087	0
Old value 45.7855	0.4087	0
New value 50.4205	0.4087	0
Work Order ID: 56302, Employee ID: LAVO01	0.4087	0
	0.4087	0
3/03/10 13:52	0.4087	0
Work Order ID: 56794, Reason: , Employee ID: DCUSER	0.4087	0
Work Order ID: 56242, Reason: , Employee ID: DCUSER	0.4087	0
Work Order ID: 57029, Reason: , Employee ID: DCUSER	0.4087	0
Work Order ID: 58514, Employee ID: FAUT01	0.4087	0
Work Order ID: 58466, Reason: , Employee ID: DCUSER	0.4087	0
Old value 50.4205	0.4087	0
New value 48.6656	0.4087	0
Work Order ID: 58514, Employee ID: FAUT01	0.4087	0
; Acct#: 60100-45; Emp ID: FAUT01	0.4087	0
Work Order ID: 59761, Reason: , Employee ID: DCUSER	0.4087	0
Work Order ID: 59822, Reason: , Employee ID: DCUSER	0.4087	0
Work Order ID: 60813, Reason: , Employee ID: DCUSER	0.4087	0
Work Order ID: 61413, Reason: , Employee ID: DCUSER	0.4087	0
Work Order ID: 61705, Employee ID: FAUT01	0.4087	0
Old value 48.6656	0.4087	0
New value 34.8088	0.4087	0



	10/05/10 15:50	0.4087	0
34.81 -> 34.54		0.4087	0
Work Order ID: 64934, Reason: , Employee ID: DCUSER		0.4087	0
Work Order ID: 65745, Reason: , Employee ID: DCUSER		0.4087	0
Work Order ID: 65836, Reason: , Employee ID: DCUSER		0.4087	0
		0.4087	0
		0.4087	0
Work Order ID: 67292, Reason: , Employee ID: DESJ02		0.4087	0
Old value 34.5372		0.4087	0
New value 37.3794		0.4087	0
Work Order ID: 66183, Employee ID: LACE01		0.4087	0
	3/29/11 10:31	0.4087	0
Work Order ID: 67644, Reason: , Employee ID: DCUSER		0.4087	0
Work Order ID: 67912, Reason: , Employee ID: DCUSER		0.4087	0
Work Order ID: 68694, Reason: , Employee ID: DCUSER		0.4087	0
Work Order ID: 67917, Reason: , Employee ID: DCUSER		0.4087	0
Work Order ID: 70537, Reason: , Employee ID: DCUSER		0.4087	0
Work Order ID: 71101, Reason: , Employee ID: DCUSER		0.4087	0
Old value 37.3794		0.4087	0
New value 20.4563		0.4087	0
Work Order ID: 71102, Employee ID: FAUT01		0.4087	0
	7/05/11 13:31	0.4087	0
Work Order ID: 71724, Reason: , Employee ID: DCUSER		0.4087	0
Work Order ID: 71204, Reason: , Employee ID: DCUSER		0.4087	0
Work Order ID: 73189, Reason: , Employee ID: DCUSER		0.4087	0
Old value 20.4563		0.4087	0
New value 7.8975		0.4087	0
Work Order ID: 71889, Employee ID: FAUT01		0.4087	0
	9/19/11 10:36	0.4087	0
Work Order ID: 75799, Reason: , Employee ID: DCUSER		0.4087	0
Work Order ID: 76067, Reason: , Employee ID: FAUT01		0.4087	0
Work Order ID: 76068, Reason: , Employee ID: FAUT01		0.4087	0
Rework ID: 76151, Reason: , Employee ID: LACE01		0.4087	0
Old value 7.8975		0.4087	0

Item ID	Trans Type	Trans Date	Inv Change Amt
D2056	Startup LOC Tracking	12/05/09 18:10	0
D2056	Account Value Change	12/05/09 18:10	0
D2056	Account Value Change	12/05/09 18:10	0
D2056	Inv Adjustment	12/05/09 18:10	199.0086
D2056	Issue	12/16/09 11:01	-132.6724
D2056	Loc Transfer	1/14/10 14:21	66.3362
D2056	Loc Transfer	1/14/10 14:21	-66.3362
D2056	Account Value Change	1/29/10 11:52	0
D2056	Account Value Change	1/29/10 11:52	0
D2056	WIP Receipt	1/29/10 11:52	457.855
D2056	Issue	2/01/10 15:43	-183.142
D2056	Lot Maintenance	2/02/10 9:02	0
D2056	Issue	2/16/10 11:21	-183.142
D2056	Account Value Change	3/01/10 10:21	0
D2056	Account Value Change	3/01/10 10:21	0
D2056	WIP Receipt	3/01/10 10:21	302.523
D2056	Lot Maintenance	3/03/10 13:52	0
D2056	Issue	3/11/10 16:31	-100.841
D2056	Issue	3/31/10 6:41	-201.682
D2056	Issue	4/12/10 8:53	-201.682
D2056	WIP Receipt	5/10/10 15:37	100.841
D2056	Issue	5/11/10 9:28	-100.841
D2056	Account Value Change	5/14/10 10:36	0
D2056	Account Value Change	5/14/10 10:36	0
D2056	WIP Receipt	5/14/10 10:36	389.3248
D2056	Inv Adjustment	6/09/10 14:34	632.6528
D2056	Issue	6/15/10 8:03	-97.3312
D2056	Issue	6/15/10 12:49	-97.3312
D2056	Issue	8/03/10 9:14	-97.3312
D2056	Issue	9/08/10 12:58	-486.656
D2056	WIP Receipt	10/05/10 13:44	437.9904
D2056	Account Value Change	10/05/10 13:44	0
D2056	Account Value Change	10/05/10 13:44	0

D2056	Lot Maintenance	10/05/10 15:50	0
D2056	Account Value Change	11/26/10 15:37	-3.8024
D2056	Issue	1/05/11 10:57	-34.5372
D2056	Issue	2/02/11 14:31	-138.1488
D2056	Issue	2/08/11 16:21	-207.2232
D2056	Loc Transfer	3/10/11 12:51	103.6116
D2056	Loc Transfer	3/10/11 12:51	-103.6116
D2056	Issue	3/16/11 15:24	-34.5372
D2056	Account Value Change	3/28/11 15:06	0
D2056	Account Value Change	3/28/11 15:06	0
D2056	WIP Receipt	3/28/11 15:06	373.794
D2056	Lot Maintenance	3/29/11 11:31	0
D2056	Issue	4/08/11 8:39	-224.2764
D2056	Issue	4/08/11 10:01	-37.3794
D2056	Issue	4/25/11 9:01	-37.3794
D2056	Issue	4/25/11 13:14	-37.3794
D2056	Issue	6/13/11 13:59	-37.3794
D2056	Issue	6/23/11 7:15	-74.7588
D2056	Account Value Change	7/05/11 11:03	0
D2056	Account Value Change	7/05/11 11:03	0
D2056	WIP Receipt	7/05/11 11:03	245.4756
D2056	Lot Maintenance	7/05/11 13:32	0
D2056	Issue	7/13/11 10:18	-20.4563
D2056	Issue	7/13/11 11:04	-81.8252
D2056	Issue	9/07/11 7:38	-20.4563
D2056	Account Value Change	9/16/11 9:47	0
D2056	Account Value Change	9/16/11 9:47	0
D2056	WIP Receipt	9/16/11 9:47	157.95
D2056	Lot Maintenance	9/19/11 10:36	0
D2056	Issue	11/02/11 11:45	-15.795
D2056	Issue	11/04/11 13:35	7.8975
D2056	Issue	11/04/11 13:38	-7.8975
D2056	Rework	11/08/11 9:55	-157.95
D2056	Account Value Change	11/08/11 9:56	0